

Date: Friday, 12/12/2008 2:21:53 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ACCESS PANEL ASSEMBLY
Job Number	: 44053		
Estimate Number	: 13039		
P.O. Number	:	Part Number	: D32561
This Issue	: 12/12/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3256 REVC
First Issue	: //	Project Number	: N/A
Previous Run	: 42471	Drawing Revision	: C
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 10/01/2009
Checked & Approved By	: <u>2008.12.15</u>	Qty:	4 Um: Each
Comment	: Est Rev:A New Issue 07-09-28 EC verified by:DD Est Rev:b ECN 1052 07-10-31 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S22GA	304/316 .032 Sheet
Comment: Qty.: 0.9870 sf(s)/Unit Total: 3.9480 sf(s) 304/316 .032 Sheet Batch: <u>109057</u> <u>B 8-12-16</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3256 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> <u>B 8-12-16</u> 2-Deburr if necessary <u>B 8-12-16</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 8-12-16</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>S 08/12/16</u> <u>47</u>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE -Form using D3256-1T2 <u>FF 09/02/09</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/09 (47)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with part# and batch# with fine point ink marker and Stock

Location: 187

9h/9

4x

SB

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/11

Job Completion



MF 09-02-10

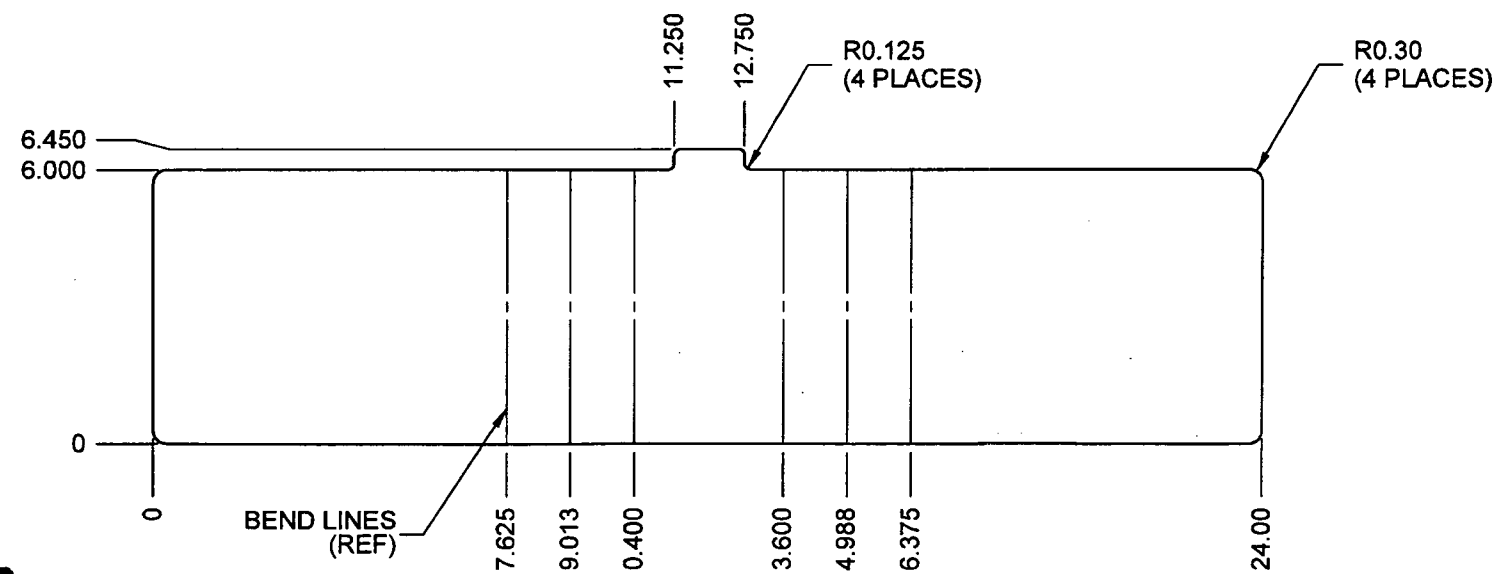
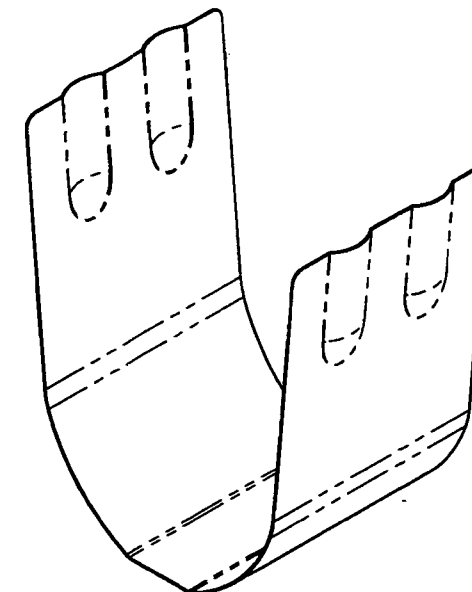
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



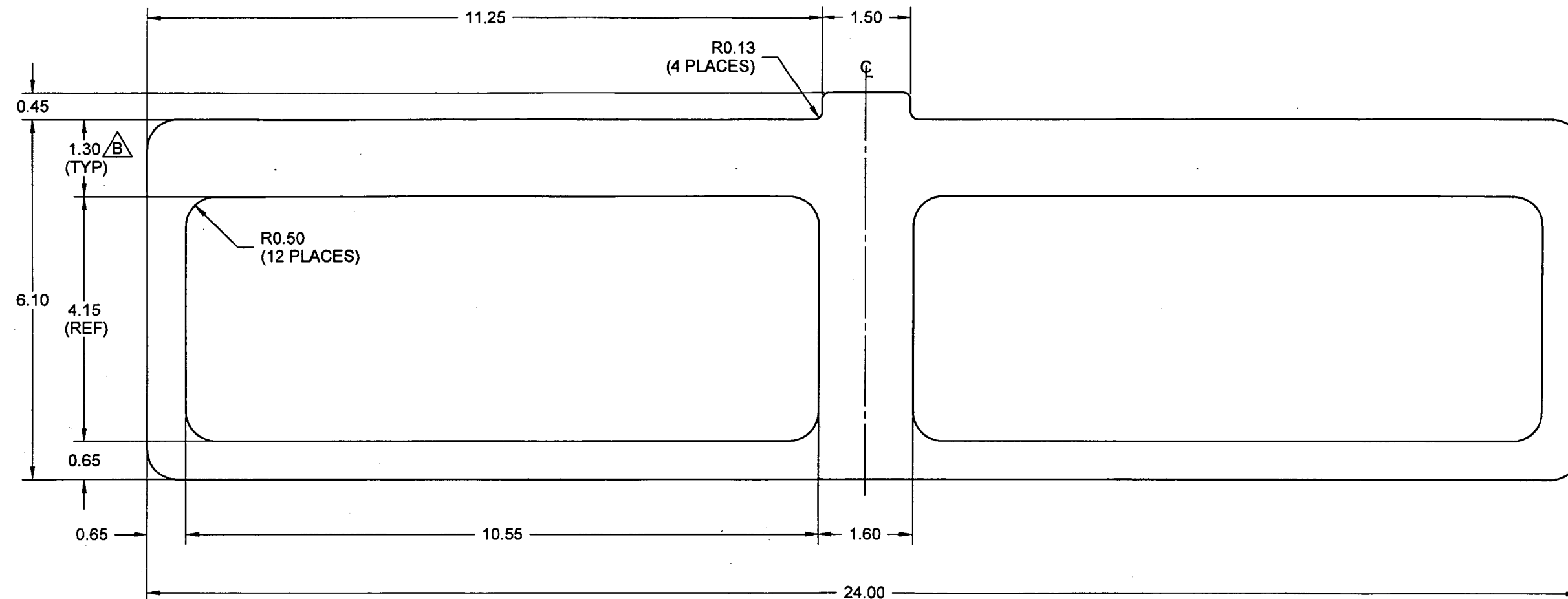
D3256-1F FLAT PATTERN

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WITHOUT NOTICE
WORK ORDER
NO. 44023

C	D3256-041 ELIMINATED: REMOVED (QTY.22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D3256	REV. SHEET 1 OF 1
DATE	07.09.28	TITLE ACCESS PANEL	SCALE 1:
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NOTES:

- NOTES:**
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.37 lbs



D3256-3 ACCESS PANEL

RELEASED
07-10-23

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WORK ORDER
NO. 44053

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK PER MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	TH	DART AEROSPACE LTD	
DRAWN	AB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV.
MFG. APPR.	DS	D3256	SHEET 2 OF
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	ACCESS PANEL	1:
DATE	07.09.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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